

alt 312X.058w

ASAP

Work Order ID 85417

June-07-12 2:00:07 PM

85417

Page 1

Item ID: D3681-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 07/06/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/09 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3681

Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

SL 12-06-09

100

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV:

DWG REV: A

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

SL 12-06-09

100

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

ent 12/06/09

100

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng.	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85417

June-07-12 2:00:07 PM

85417

Page 2

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Accept

N900040100

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Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 07/06/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

125

Skidtubes

Memo

0:00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

100 0 BE 12/06/15

130

130

Packaging

Identify as per dwg & Stock Location: **LG**

0:00

Packaging

Memo

0:00

STOCK IN SKIDTUBE CELL

100 0 BE 12/06/15

140

140

QC

QC21- Final Inspection - Work Order Release

0:00

Quality Control

Memo

0:00

12/6/18

ME 12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-07-12 2:00:10 PM

Page 1

Work Order ID: 85417

85417

Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 07/06/2012

Required Date: 14/06/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD
seq 125 DD 10.05.03 verified by:EC

IPP Rev:C add

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No			100	f	227.4210	0.34	35.78947			

M6061T6T0.3125W.058

ALUM TUBE .3125 x .058w

**

SL 12-06-09

Location

Loc Qty

Loc Code

MAT013

227.421

119678

23.421

121910

204

* 10.88
24.92

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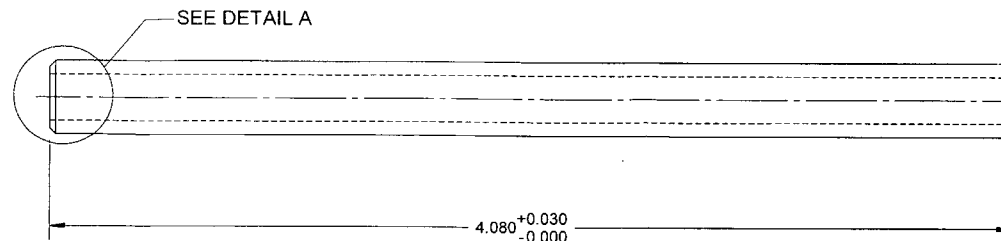
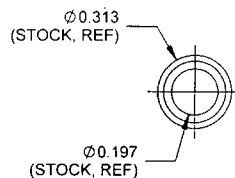
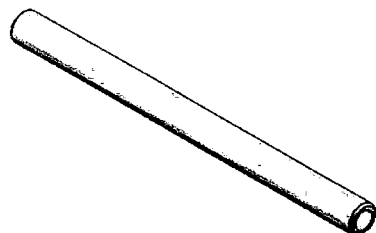
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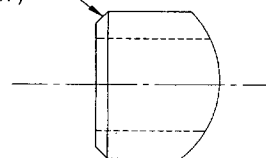
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D3681-1 SPACER

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4:1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85477 MLJ

12/06/07

RELEASED
07-11-09

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	DC	07.11.08
REV	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	MD	DRAWING NO.	REV. A
MFG. APPR.	ED	D3681	SHEET 1 OF 1
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SPACER	2:1
DATE	07.11.08	COPY RIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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